

Work Order ID 126803

November-26-14 7:28:44 AM

*ASAP*

\*126803\*

Page 1

Item ID: 646.9711

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Blade

Start Date: 11/26/14 Start Qty: 50.00

\*50\*

Cust Item ID:

Required Date: 12/05/14 Req'd Qty: 50.00

\*50\*

Customer:

Reference:

Approvals:

Process Plan: *h*

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
646.9700	C (ECN)

100

0.00

\*100\*

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank at 4.625"

50

Ø

DAS

37

9-89

14.11.29

110

0.00

\*110\*

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB135

DWG REV: *C*

FOLIO REV: *AA*

50

DAS

37

9-89

14.11.29

2- deburr and break all sharp edges except otherwise noted

KNIFE EDGE MUST BE SHARPENED USING STONE, REMOVE ALL  
BURRS ON CUTTING EDGE

*14/12/03*

# Work Order ID 126803

November-26-14 7:28:44 AM

**\*126803\***

Page 2

Item ID: 646.9711 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Blade  
 Start Date: 11/26/14 Start Qty: 50.00 **\*50\*** Cust Item ID:  
 Required Date: 12/05/14 Req'd Qty: 50.00 **\*50\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 37 9-89 14.11.29
<b>*120*</b>						50			
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							DAS 44 9-89 14/12/03
<b>*130*</b>						50	0		
QC	Memo	0.00							
Quality Control									
140	Outsource process - Heat Treat	0.00							
<b>*140*</b>									CL 14/12/05 (50)
Outsource1	Memo	0.00							
Outsource process - Heat Treat	HEAT TREAT AS PER DWG, SEE NOTE #3								
	ISSUE P/O: 26736								

# Work Order ID 126803

November-26-14 7:28:44 AM

**\*126803\***

Page 3

Item ID: 646.9711 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Blade  
 Start Date: 11/26/14 Start Qty: 50.00 **\*50\*** Cust Item ID:  
 Required Date: 12/05/14 Req'd Qty: 50.00 **\*50\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
<b>*150*</b>									
Packaging	Memo	0.00							
Packaging									
155	QC5- Inspect part completeness to step on W/O	0.00							
<b>*155*</b>									
QC	Memo	0.00							
Quality Control									
160	Spray Painting per QSI005 4.2	0.00							
<b>*160*</b>									
SprayPaint	Memo	0.00							
Spray Painting	PRIME AS PER DWG, SEE NOTE #4								
	PRIMER BATCH: <u>m131121</u>								

50x 8/14/12-16

(50) DAS 38 9-89

DEC 16 2014

(50) 14-12-22

# Work Order ID 126803

November-26-14 7:28:44 AM

**\*126803\***

Page 4

Item ID: 646.9711 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Blade  
 Start Date: 11/26/14 Start Qty: 50.00 **\*50\*** Cust Item ID:  
 Required Date: 12/05/14 Req'd Qty: 50.00 **\*50\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC14- Inspect Spray Paint	0.00							DAS 41 9-89
<b>*170*</b>						50			
QC	Memo	0.00							14-12-23
Quality Control									
180	Identify as per dwg & Stock Location: <u>MF1</u>	0.00							DAS 41 9-89
<b>*180*</b>						50			
Packaging	Memo	0.00							14-12-23
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

15/1/5 JF  
 4-12-23

# Picklist Print

November-26-14 7:28:43 AM

Page 1

Work Order ID: 126803

**\*126803\***

Parent Item: 646.9711

**\*646 9711\***

Parent Item Name: Blade

Start Date: 11/26/14

Required Date: 12/05/14

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP REV:A NEW ISSUE 12/09/24 JFS VERIFY BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MSTEEL-A2- B0.500X1.250		Purchased		No		100	f	127.6680	0.386	21			

**\*MSTFFI -A2-B0 500X1 250\***

AISI A2 TOOL STEEL BAR, 0.500 X 1.250

**\*\***

DAS

37

9-89 / 4.11.29

Location

Loc Qty

Loc Code

MAT010

127.668

M126438

114

M127494

13.668

21 ft.

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	126803
<b>Description:</b> Blade	<b>Part Number:</b>	646.9711
<b>Inspection Dwg:</b> 646.9700 <b>Rev:</b> C		<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

**DAS**

Measured by:	37 9.80
Date:	14-11-79

Rev	Date	Change	Revised by	Approved
A	13.06.03	New Issue	KJ	
B	13.06.27	Dwg Rev updated	KJ	
C	13.07.18	Dwg Rev updated	KJ	
D	13.08.23	Dimensions revised	KJ	
E	13.11.26	Dwg Rev updated	KJ	

# APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04559

SHEET 1 OF 1

DWG NO. 646.9700

REV: C

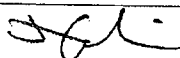
PREPARED BY D. MEJIA

DATE: 06/11/2014

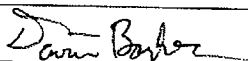
EFFECT ON DWG  
☐ INC. ☒ UNINC.

DWG TITLE: CUTTER SUB ASSY

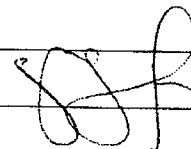
APPROVED BY: ENGR



MFG



QC



EFF.

NEXT ORDER

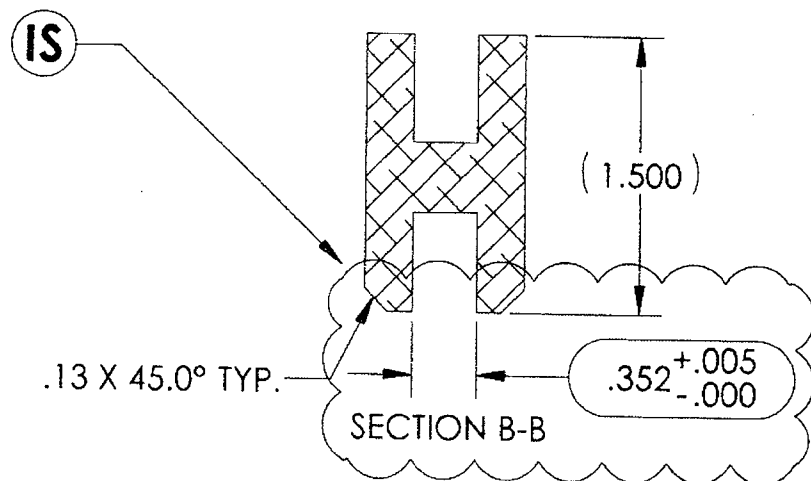
TRANSACTION CODES (TC):  
A-ADD  
R-REVISE  
C-CREATE  
D-DELETE

REASON: ADDED DIMENSION AND TOLERANCE

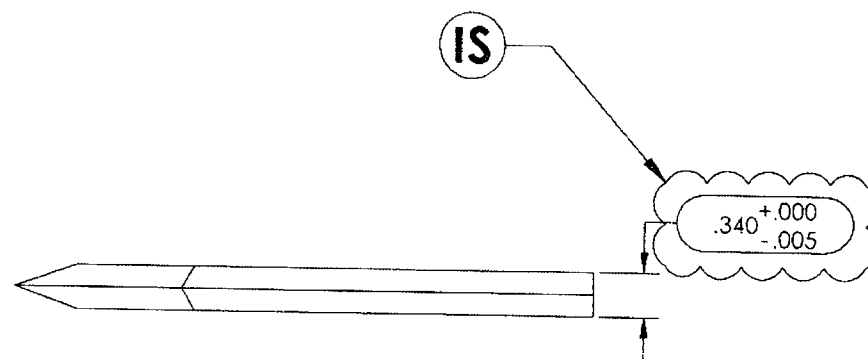
ECR:

D-14-05

SHEET 2, ZONE D7 IS:



SHEET 5, ZONE B5 IS:



W/O 126803

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

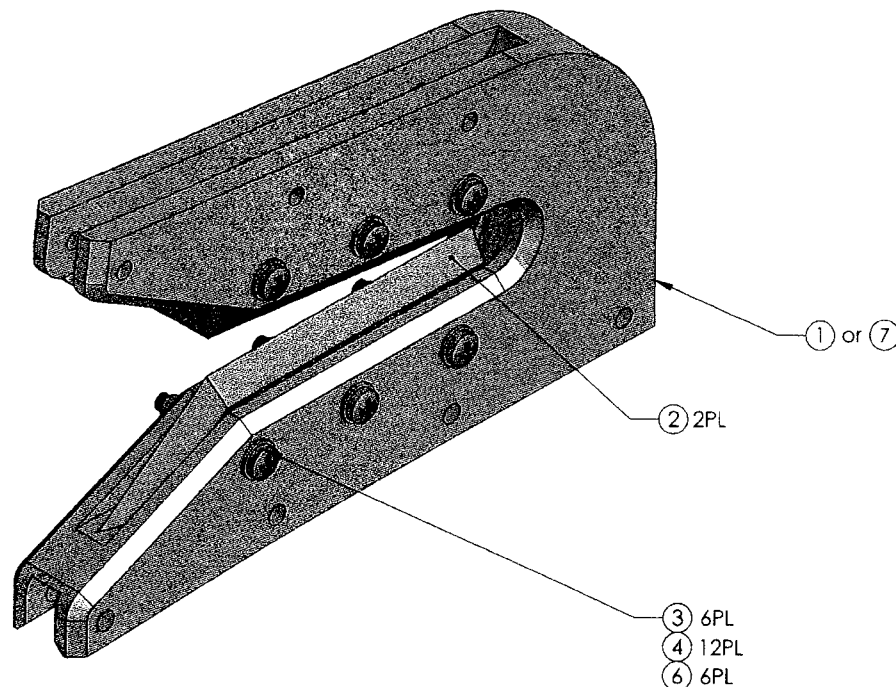
☐ YES ☒ NO

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REV	DESCRIPTION	DATE	APPROVED
1	LAST PRODUCTION REVISED P12		MJC
2	INITIAL RELEASE	05/27/09	F. BRAYO
3	INCORPORATED ECN 02741, 02936, 10912	06/01/13	F. BRAYO
4	INCORPORATED ECN 03067	07/03/13	F. BRAYO
5	INCORPORATED ECN 04531	08/09/13	F. BRAYO

# NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;  
PRETREAT PRC-DESOTO PR-148 ADHESION PROMOTER;  
PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
- 3 MATERIAL: AISI A2 TOOL STEEL  
CONDITION: ANNEALED  
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- 4 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
- 5 DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
- 6 IDENTIFY IAW MPP-120
- 7 APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2 UPON ASSEMBLY
- 8 CUTTING EDGE INTENDED TO BE SHARP. DO NOT BREAK SHARP EDGE
- 9 ALL DIMENSIONS NOT SPECIFIED ARE CONTROLLED BY 646.9710.



646.9701  
or  
646.9702

UNINCORPORATED ECN(s)

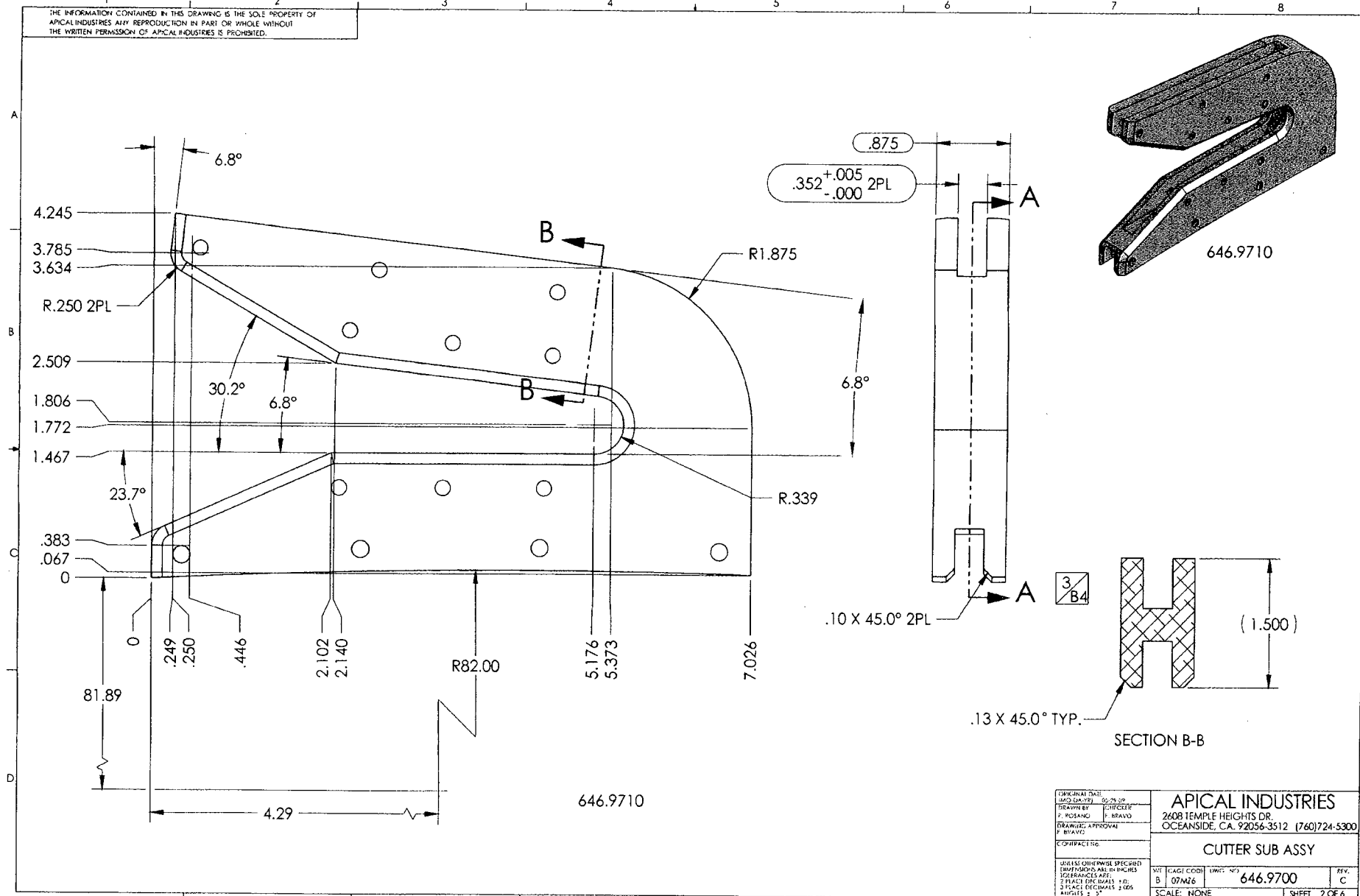
04554

QTY	REV	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
1	7		646.9712	BODY (U CHANNEL)	1	1
6	6		601.1541	LOCKNUT	MS21042L08	
A/R	A/R		601.2764	RTV, LOCITE 598		
12	12		601.2764	WASHER	HA5114R-NB70P	
6	6		601.2765	SCREW	MS27039-0819	
2	2		646.9711	BLADE	1	1
1	1		646.9710	BODY	1	1
			646.9702	CUTTER SUB ASSY (U CHANNEL)		
			646.9701	CUTTER SUB ASSY		
646.9702	646.9701					
PARTS LIST						
NEXT ASSY (S)				APICAL INDUSTRIES		
646.9600				2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300		
				CUTTER SUB ASSY		
				DATE	SCALE	REV.
				8	07M26	646.9700 C
				SCALE NONE SHEET 1 OF 6		



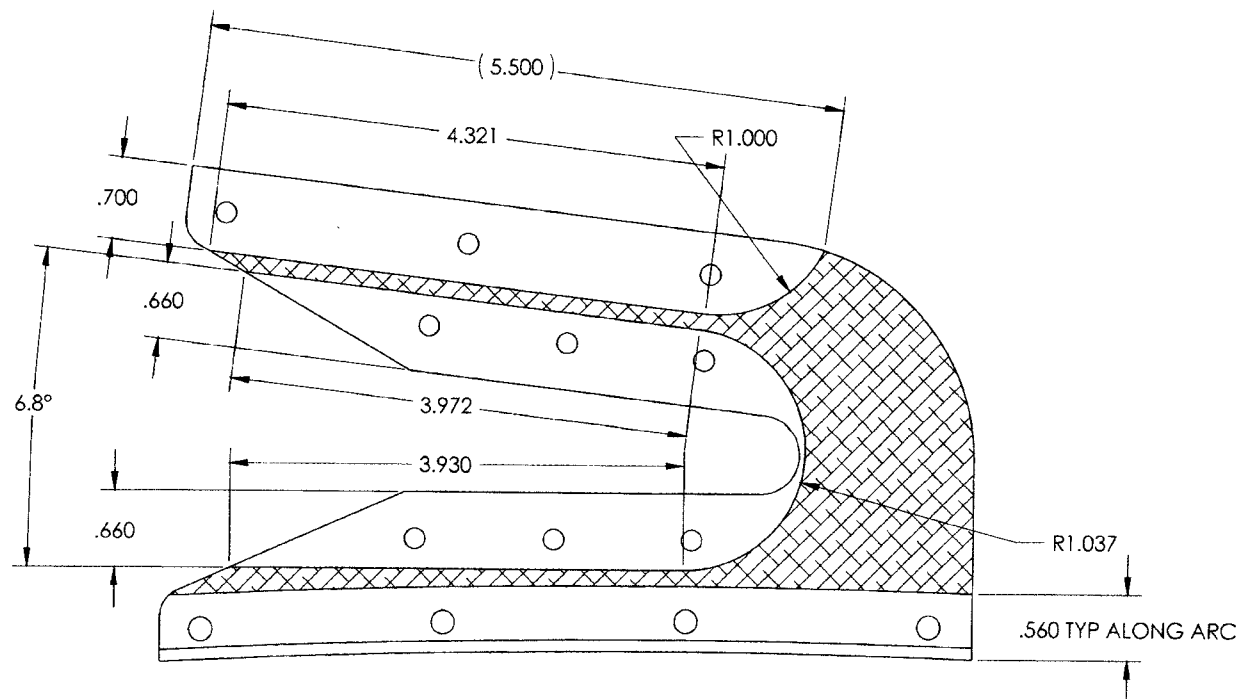
1 2 3 4 5 6 7 8

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ORIGINAL DATE: 10/20/98		APICAL INDUSTRIES	
DRAWN BY: F. ROSANO		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: F. BRAVO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL: F. BRAVO		CUTTER SUB ASSY	
C/SHIPART NO:		646.9700	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.015 3 PLACE DECIMALS ±.005 ANGLES ± 5°		REV. C	
SCALE: NONE		SHEET 2 OF 6	

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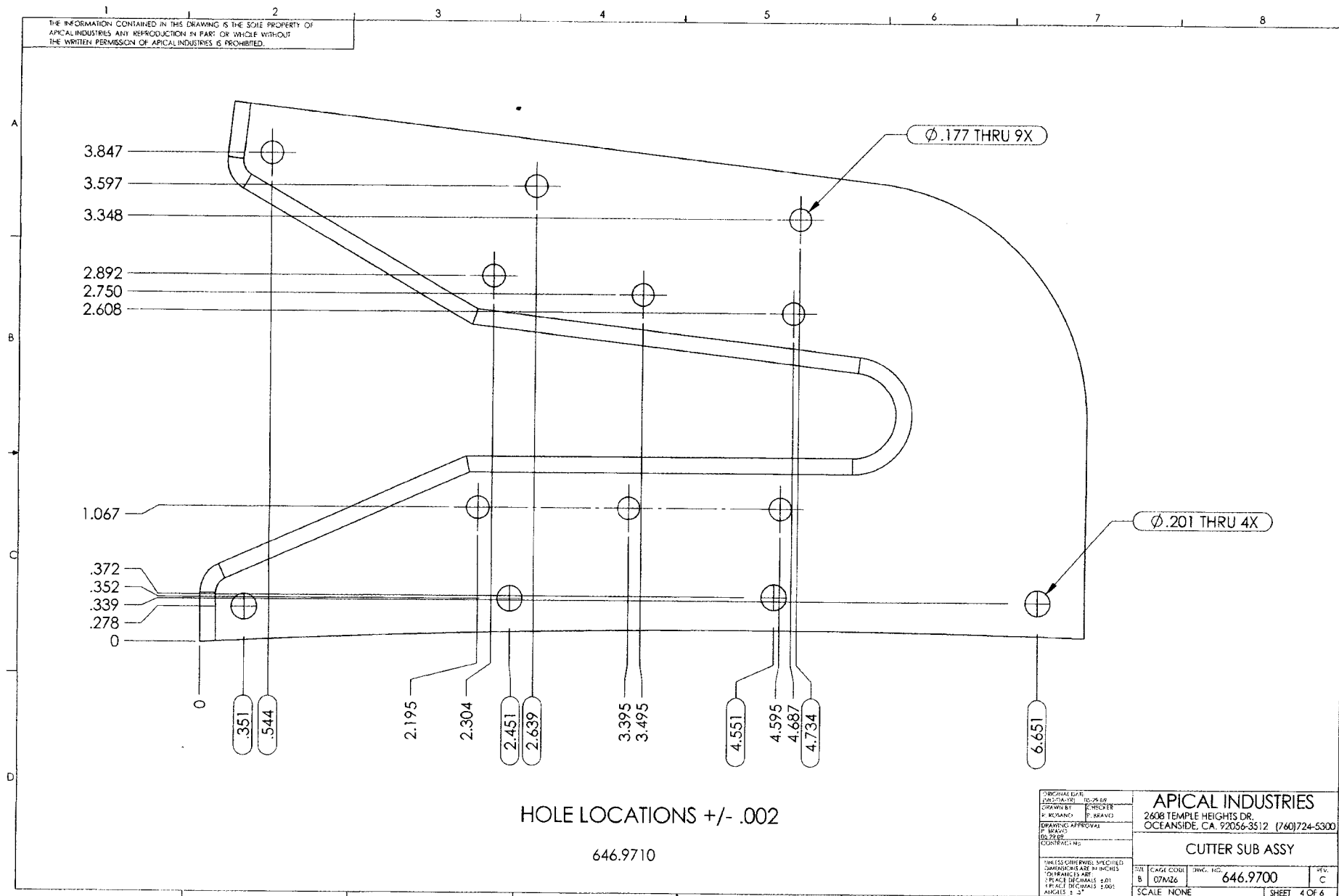


SECTION A-A  $\frac{2}{C6}$

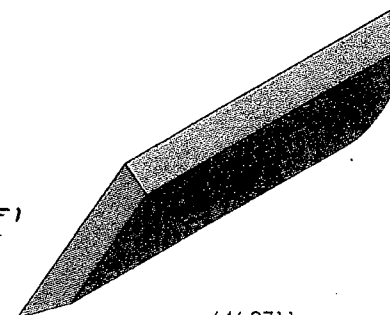
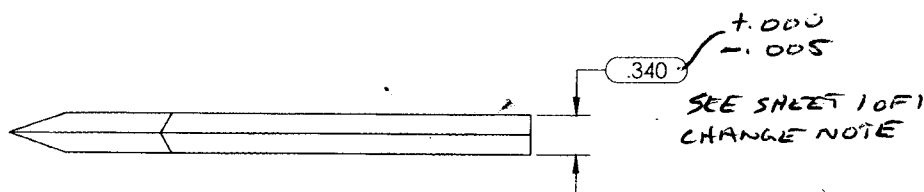
646.9710

ORIGINAL DATE 08-01-80		APICAL INDUSTRIES	
DRAWN BY H. ROSARIO		2608 TEMPLE HEIGHTS DR.	
CHECKED BY P. BRAYO		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL P. BRAYO		CUTTER SUB ASSY	
DATE 08-01-80			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .005 3 PLACE DECIMALS ± .0005 ANGLES ± .1°		SHEET B	REV. C
		CAGE CODE 07M26	UNCL. NO. 646.9700
		SCALE NONE	SHEET 3 OF 6

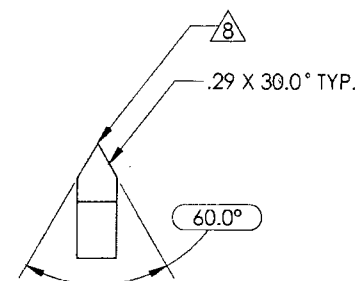
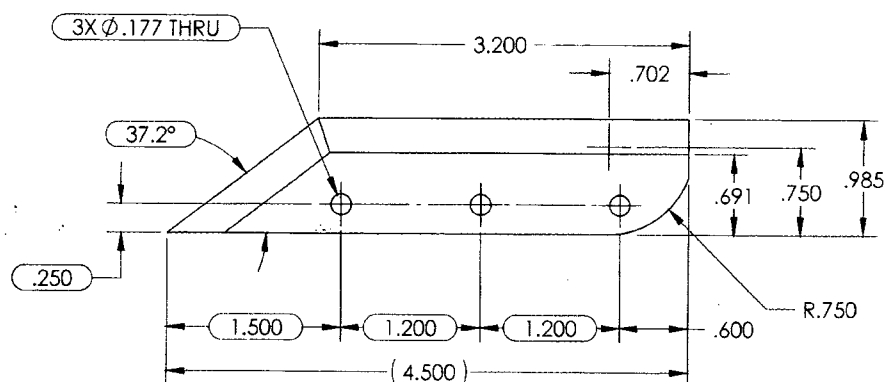
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646.9711



646.9711

ORIGINAL DATE  
DESIGNED BY  
P. P. C. S. INC.  
DRAWING APPROVAL  
P. P. C. S. INC.  
CONTRACTING

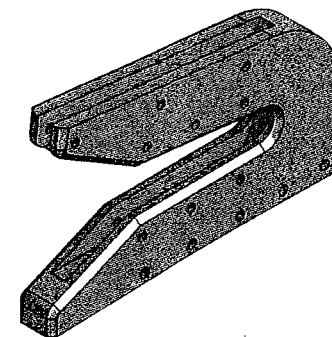
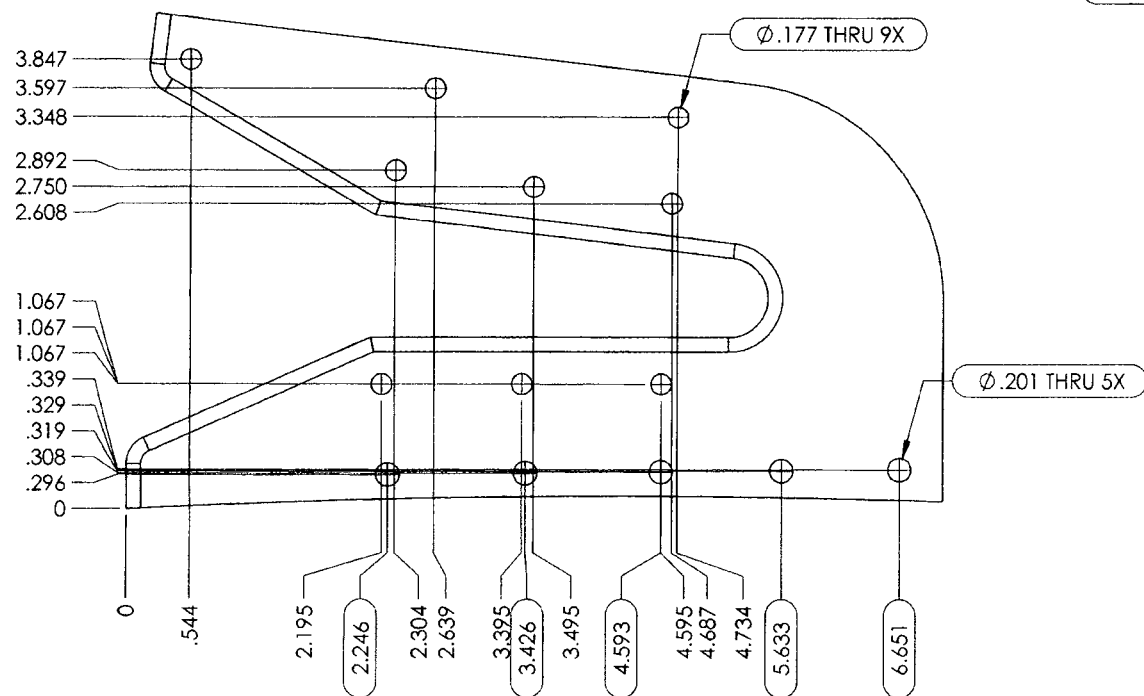
APICAL INDUSTRIES  
2608 TEMPLE HEIGHTS DR.  
OCEANSIDE, CA. 92056-3512 (760) 724-5300

CUTTER SUB ASSY

THREE COMMON SPECIFIED  
DIMENSIONS ARE IN INCHES  
UNLESS OTHERWISE SPECIFIED  
2. PLACE DIMENSIONS IN INCHES  
3. PLACE DIMENSIONS IN INCHES  
ANGLES IN DEGREES

REV	DATE	BY	DESCRIPTION
B	07/26	646.9700	C
SCALE: NONE		SHEET 5 OF 6	

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646.9712  $\triangle 9$

646.9712

CARRIER: DPH MOD: DA 101		DS-22 0V DATE: 01/10/10		<b>APICAL INDUSTRIES</b> 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY: R. ROSANO CHECKED BY: P. BRAVO		DRAWING APPROVAL: P. BRAVO 05/28/09 COMMENTS:		<b>CUTTER SUB ASSY</b>	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .001$ ANGLES $\pm .5^\circ$		S/N: B CAGE CODE: 07M26	ENG. NO.: 646.9700	REV: C	SCALE: NONE SHEET: 6 OF 6



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO26736**

Purchase Order Date 12/5/2014

PO Print Date 12/5/2014

Page Number 1 of 2

Order From :  
METCOR INC.  
560 BOUL. ARTHUR SAUVE  
SAINT-EUSTACHE, QC J7R 5A8  
CA

VC-MET004

Ship To : DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

FL

Contact Name  
Vendor Phone 450 473 1884  
  
Ship To Contact  
Ship To Phone  
Ship Via: FedEx Overnight collect  
Ship Acct:

Buyer  
Customer POID  
Customer Tax # 10127-2607  
Terms Net 30  
Currency CAD  
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	126803	646.9711 BLADE	12/15/2014 Yes 12/15/2014		50.00 ✓	\$5.58	\$279.0
	FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS  PART ARE MADE FROM AISI A2 TOOL STEEL  PLEASE NOTE: DETAIL C OF C REQUIRED						
Line Total:							\$279.0
2	71401-45	PROCUREMENT QUALITY CLAUSES	12/15/2014 No 12/15/2014		1.00	\$0.00	\$0.0
	Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A020 non-destructive test/inspection identification A021 dart aerospace processing A024 process certifications A026 certification of material conformance						

SP 14-12-16

Note:

12/5/2014

# METCOR INC.

550 BOUL ARTHUR SAUVÉ  
ST-EUSTACHE, QC J7R 5A8  
Tel: 450-473-1884 / Fax: 450-491-5498

## Recu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
201202	1	86991

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT / Customer 215

DART AEROSPACE  
1270 ABERDEEN  
HAWKESBURY ON K6A 1K7  
Ph: 613-632-5200  
Fax: 613-632-1053

LIVRE À / Shipped To

DART AEROSPACE  
1270 ABERDEEN  
HAWKESBURY ON K6A 1K7  
Ph: 613-632-5200  
Fax: 613-632-1053



COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
26736		A2	2014/12/8	FEDEX

QUANTITÉ Quantity	No. PIÈCE Part No.	NOM DE LA PIÈCE Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
----------------------	-----------------------	------------------------------	---	-----------------

✓ 50 646 9711  
(50) 646 9711

126803

14,

*SP14-12-16*

1 BOITE DE CARTON

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
-------------------------------------	------------------------------------	--

BOITE DE CARTON

certificat

EMPAQUETAGE Packing
------------------------

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 50

POIDS EXPÉDIÉ / Weight Shipped : 14,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

certificat

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 50

POIDS EXPÉDIÉ / Weight Shipped : 14,00

Signature:

Date:

**METCOR INC.**

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

**Rapport d'Inspection****Inspection Report**

BON DE TRAVAIL order	CHARGEMENT load
201202	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
26738		A2		
<b><u>SPÉCIFICATIONS DU PROCÉDÉ</u></b> processing specifications				
VAC HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
HARDNESS	58 - 82 HRC	5	80 - 81 HRC	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
✓ 50	14	848.9711 (50) 848.9711  126803  1 BOITE DE CARTON		

*SP14-12-16*

*9 Dec*

**COMMENTAIRES / comments**APPROUVÉ par / Approved by: *[Signature]*

DATE: 2014-12-09



# METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

## Certificat de Conformité Détaillé.

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
201202	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
26736		A2		
<u>SPÉCIFICATIONS DU PROCÉDÉ</u> processing specifications				
VAC HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed		RÉSULTATS DE TESTS / results	
HARDNESS	58 - 62 HRC		5 60 - 61 HRC	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
50	14	646.9711 (50) 646.9711  126803  1 BOITE DE CARTON		

8014-12-15.

### COMMENTAIRES / comments

DOUBLE TEMPER 400F, 2 HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

APPROUVÉ par / Approved by: Isabel Otero QA Technician METCOR 12 DATE: 2014-12-10